

Work Order ID 104430

104430

Page 1

July-10-13 2:53:31 PM

Item ID: 647.2113

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lower Rail, U-Channel

Start Date: 7/10/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/11/13

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

647.2100

B

M

100

Manufacture as per dwg

0.00

100

Mill Conv

Memo

0.00

Conventional Milling Machine

pull fromk stk:

1 x 647.2110 B

185082

u

1307-10

open 4 holes of .201 to .250

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

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Page 2

July-10-13 2:53:31 PM

Item ID: 647.2113

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lower Rail, U-Channel

Start Date: 7/10/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/11/13 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						1	0	0	AS 13-7-11
HandFinish	Memo	0.00							
Hand Finishing	touch up alodine A/R touch up primer A/R								
140	QC3- inspect Part Finish	0.00				1			DAS 05 13-07-11
140									
QC	Memo	0.00							
Quality Control									
150		0.00				1			DAS 05 13-07-11
150									
Packaging	Memo	0.00							
Packaging	re-identify using new B/N								

Ship
50112205 1X

SP 13-7-11

Work Order ID 104430

104430

Page 3

July-10-13 2:53:31 PM

Item ID: 647.2113

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lower Rail, U-Channel

Start Date: 7/10/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/11/13 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 13-0711

MF

13-7-14

Picklist Print

July-10-13 2:53:29 PM

Page 1

Work Order ID: 104430
Parent Item: 647.2113
Parent Item Name: Lower Rail, U-Channel

Start Date: 7/10/13
Start Qty: 1.00
Required Date: 7/11/13
Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.2110 Lower Rail		Manufactured	No				Each	15.0000		1			

Location

ST139C

125082

Loc Qty

15

15

Loc Code

WKF 13-7-11

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03956

SHEET 1 OF 1

DWG NO. 647.2100

REV: A

PREPARED BY:

J. BECKER

DATE: 07/01/13

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: MOUNTING RAIL

APPROVED BY:

ENGR

MFG

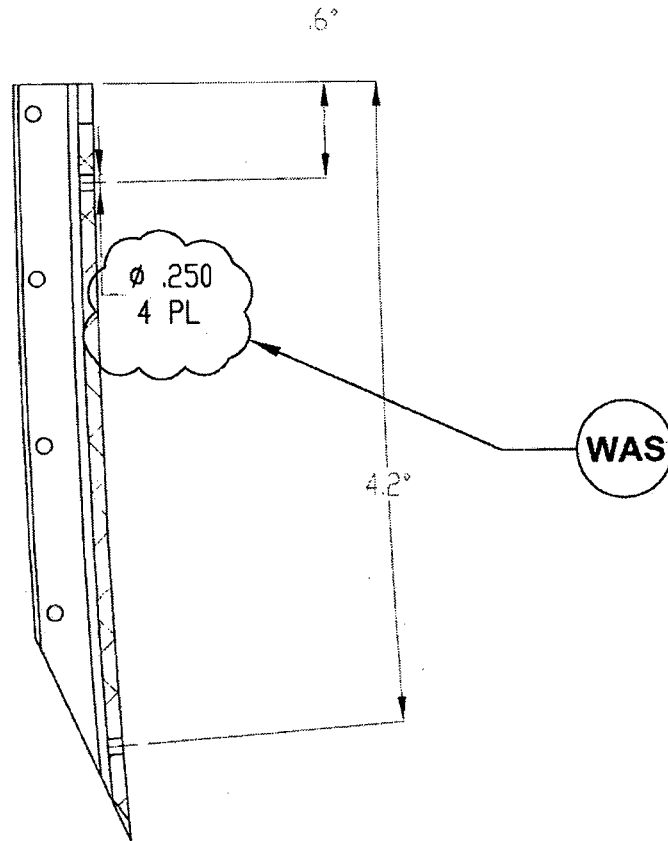
QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC)
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: ADDED 647.2113. ADDED SHEET 4.

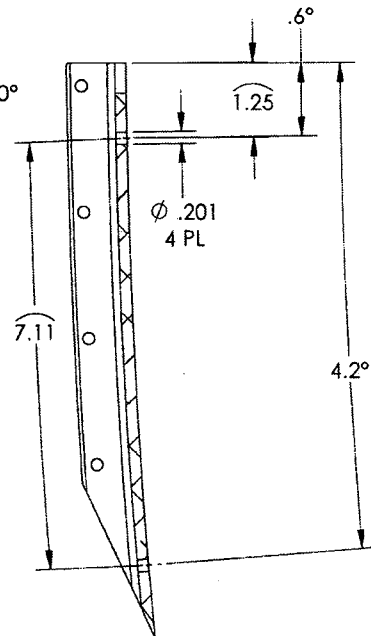
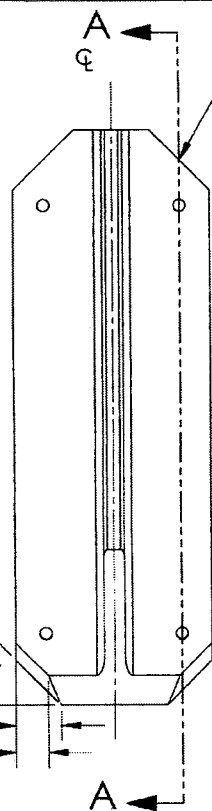


SECTION A-A

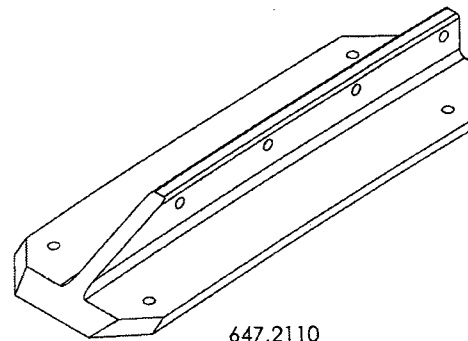
SHEET 1, ZONE A3:

4	C	647.2113			LOWER RAIL (U CHANNEL KIT)	1	2
F/N	TC	PART NUMBER	QTY		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM						<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

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SECTION A-A

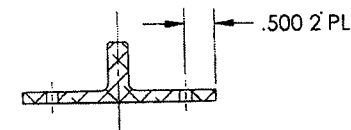
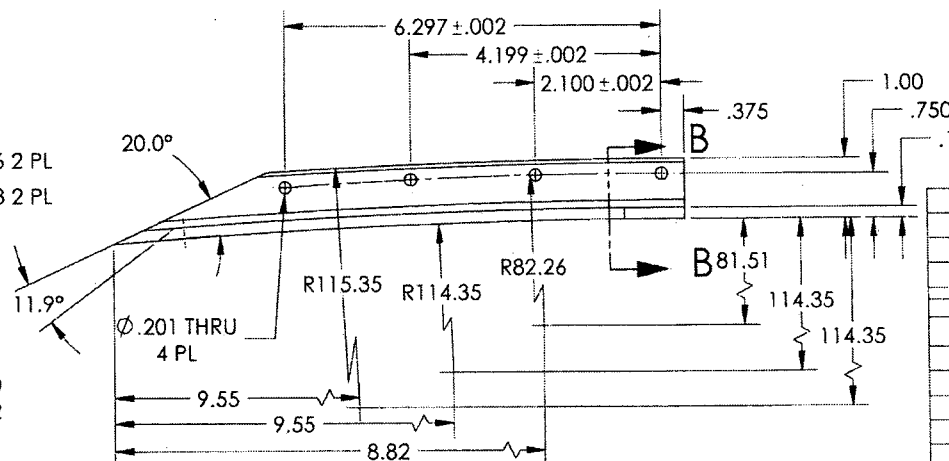
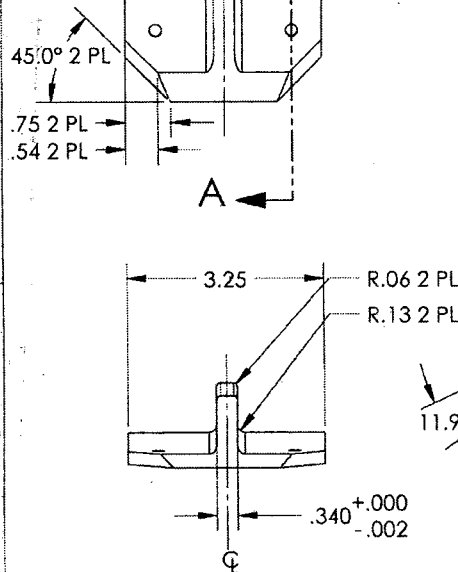


647.2110









REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISED PER		INTC
2	INITIAL RELEASE	08/01/13	P. BRAVO
3	INCORPORATED FOR 02/13 02/13 02/13	08/01/13	P. BRAVO
4	INCORPORATED FOR 02/13	07/01/13	P. BRAVO

NOTES:

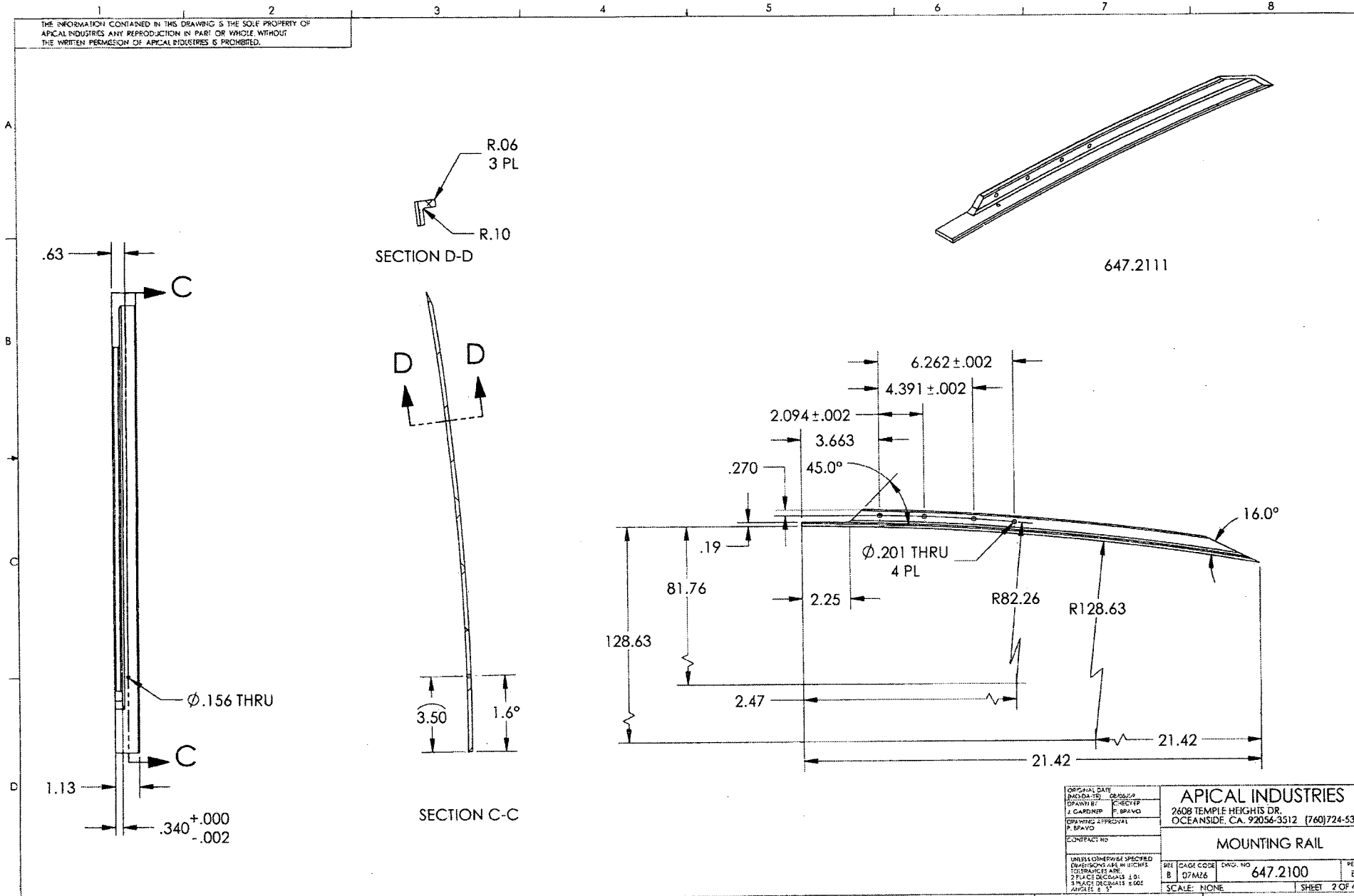
- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 3 DEBURR AND BREAK ALL SHARP EDGES
- 4 IDENTIFY IAW MPP-120.
- 5 HOLE LOCATIONS CONTROLLED BY 647.2110.



SECTION B-B

		4	647.2113	LOWER RAIL (U CHANNEL KIT)		
		3	647.2112	UPPER U CHANNEL		
		2	647.2111	UPPER RAIL		
		1	647.2110	LOWER RAIL		
FIND #		PART #		DESCRIPTION	MAT'L	SPEC
QTY						
NEXT ASSY (S)				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
647.1300						
DRAWING APPROVAL P. BRAVO 08/01/13 CONTRACT NO.				MOUNTING RAIL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5°						
REV: 6				DATE: 07/01/13	647.2100	REV: B
SCALE: NONE				SHEET 1 OF 4		

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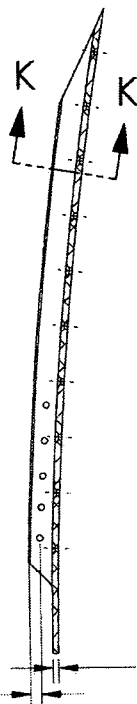
ORIGINAL DATE INCHES TO: 1/8" = 1'-0"		APICAL INDUSTRIES	
DRAWN BY: J. GARDNER	CHECKED BY: P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAVO		MOUNTING RAIL	
CONTRACT NO.		647.2100	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.001 ANGLES ±.5°		SHEET 2 OF 4	REV B

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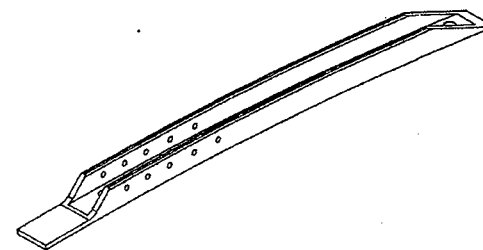
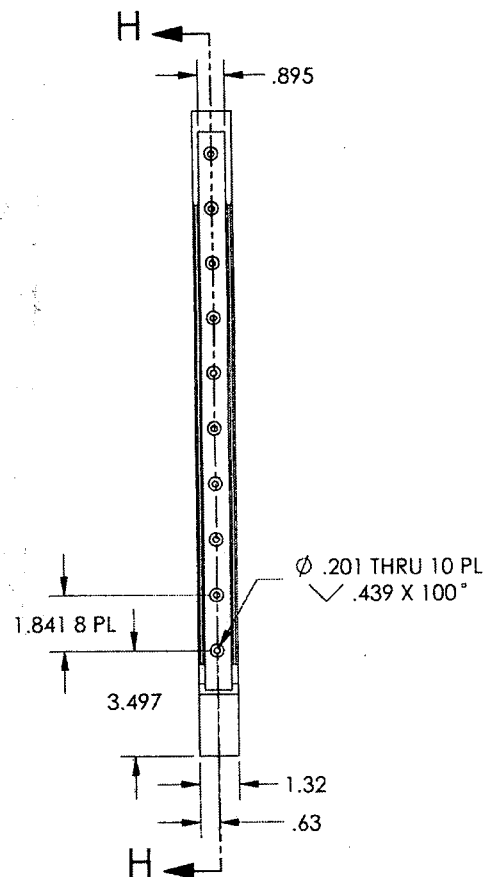
R.06 4 PL



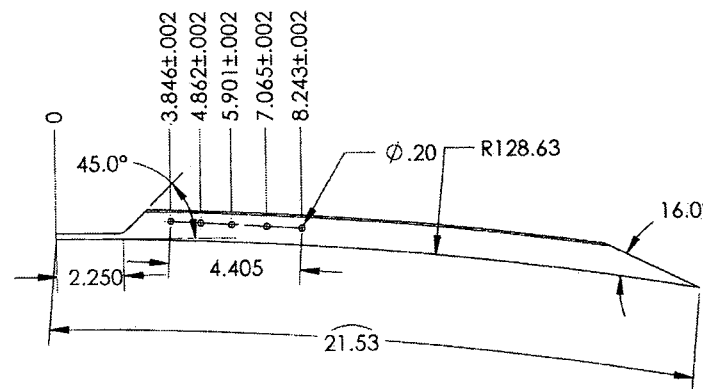
SECTION K-K



SECTION H-H



647.2112



ORIGINAL DATE 06/05/97
 (MODIFIED)
 DRAWN BY J. GARDNER
 CHECKED P. BRAVO
 SUBMITTING APPROVAL P. BRAVO 06/06/98
 CORRECTED NO

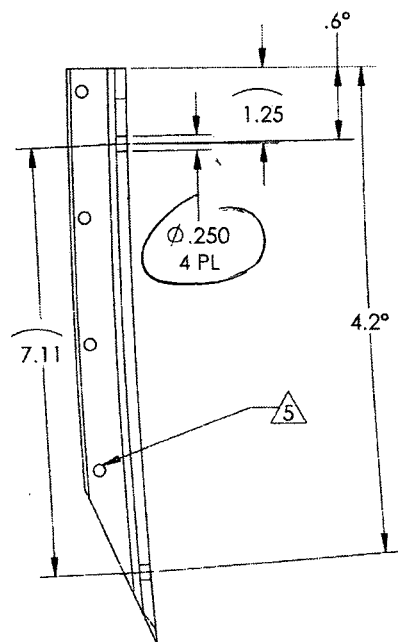
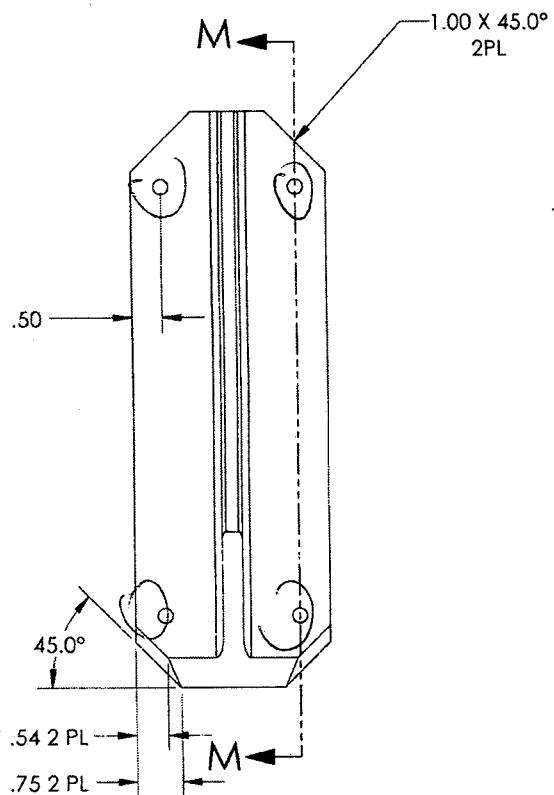
UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 TOLERANCES ARE:
 2 PLACE DECIMALS ±.01
 3 PLACE DECIMALS ±.005
 ANGLES ± 5°

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760)724-5300

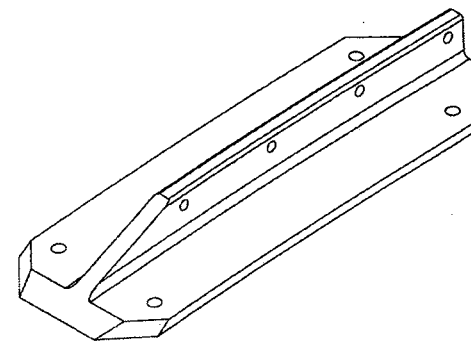
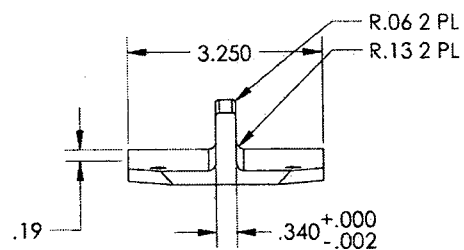
MOUNTING RAIL

SIX	CAGE CODE	QWID. NO.	REV.
B	07/M16	647.2100	3
SCALE NONE			SHEET 3 OF 4

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SECTION M-M



647.2113

ORIGINAL DATE 08/05/09		APICAL INDUSTRIES	
DRAWN BY J. GARDNER		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DESIGNED BY P. BRAVO		MOUNTING RAIL	
CONTRACT NO.		REV. B	
UNLESS OTHERWISE SPECIFIED		DWG. NO. 647.2100	
DIMENSIONS ARE IN INCHES		SCALE NONE	
TOLERANCES ARE:		SHEET 4 OF 4	
2 PLACE DECIMALS .00			
3 PLACE DECIMALS .000			
ANGLES ± .5°			

